



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

## Inprocess Inspection (Pollot Dies)

10438

| S.No. | Check Parameter                       | Specification          | Observations           | Remarks            |
|-------|---------------------------------------|------------------------|------------------------|--------------------|
| 1     | Work Order No.                        |                        | 15692                  | 25/66              |
| 2     | Machined By                           |                        | V. T. L. n/c Shop      | Dy. M. 1 & 2. 320  |
| 3     | Pallet Die No.                        |                        | 15568 (6.0) n/c        | Rev. 08            |
| 4     | Die Category                          | Drg. No.               | N. Jumbo               |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 680.2 n/c              | Step 00. 693 n/c   |
| 6     | Inside Diameter                       | Drg. No.               | 546.14 n/c             | (800.548.2) n/c    |
| 7     | Width of Pellet Die                   | Drg. No.               | 195 n/c                | Step length. 314   |
| 8     | Grooves as per Drawing                | Drg. No.               | 32 x 7 x 9.1 n/c       | End cut. 8.7       |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 32 x 7 x 9.1 n/c       | (4 x 8)            |
| 10    | Drilling Area Surface Smoothness      |                        | ok                     | Face Side Step     |
| 11    | Tapping Operator                      |                        | n/c Shop               | 8 n/c Deep         |
| 12    | Tapping PCD                           |                        | 619 n/c                | Both Side          |
| 13    | Tapping Hole Diameter                 |                        | M16. Check by M16 Bolt | Tapping No.        |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                     | of holes. 2        |
| 15    | Tapping Hole Depth                    |                        | Drill Depth. 33.7 n/c  | Both Side          |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                    | Tapping Depth 31.7 |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                     |                    |

### Inspected By (Sign) & Date

Ravi 7/8/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 1 | As per programme no.           |        |    |
| 2 | Gun Drilling Work Completed On |        |    |
| 3 | Hole Finish In Gun Drilling    | Marked | ok |
| 4 | Defective Holes (If Any)       |        | No |

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter. 30  
Rev. 12

|   |                                            |         |  |              |   |    |  |
|---|--------------------------------------------|---------|--|--------------|---|----|--|
| 1 | Counter Sinking Depth & Finish             | ok      |  |              |   |    |  |
| 2 | External Relief Dia                        | 4.0 n/c |  | All Rows     |   |    |  |
| 3 | External Relief Depth                      |         |  | 41 n/c       |   |    |  |
| 4 | Inspection Done Before Hardening By (Name) |         |  | Ravi         |   |    |  |
| 5 | Material Sent For Hardening By (Name)      |         |  | Lark Furnace |   |    |  |
| 6 | Material Sent For Hardening On Date        |         |  | 7            | 8 | 25 |  |

### Inspected By (Sign) & Date

Ravi 7/8/25

Reviewed by (Engineer-CNC)

Manager-QA